



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE703A94-1130-01-27

Job Sheet 197537



Part No: RBE703A94-1130-01-27

Job Qty: 6 pcs

Part Name: Tab Adjuster Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/10/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 REV K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
105	Bandsaw - 1	6 pcs	9/2/19	9/2/19	0.00	0.60	Bandsaw - 1		
110	NV5000 - 1 - B4B	6 pcs	9/2/19	9/2/19	1.00	6.00	NV5000 - 1 - B4B		
							NV5000 - 2 - B4B		
120	QC 2	6 pcs	9/2/19	9/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

AL.A. Fink

7/26/19

QC 2 - 10 - 07 - 29



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S200867



Part: RBE703A94-1130-01-27

Job No: 197537

Serial No/Batch: S200867

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 9/26/19

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	6 pcs	9/2/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
150	Outsource - 4 - Anodize	6 pcs	9/2/19		ATC001-VC-GROUPE
160	Packaging 2-1 - Receive - B4B	6 pcs	9/2/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B

A. 19-07-29

K 2019-07-31

DP AUG 06 2019

					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
					QC 6 - 68	
170 QC 6	6 pcs	9/2/19	0.00 0.00		QC 6 - 61	DAS
					QC 6 - 40	61
					QC 6 - 81	9-89
180 Packaging 3-1 - Stock - B4B	6 pcs	9/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
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					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	6 pcs	9/2/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 105 - Bandsaw - Cut blanks at 4.25"

Descriptions: 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE 1-Machine as per folio FB582 FOLIO REV: AA DWG

REV: K 2-Deburr

120 - QC2- Inspect parts off machine FAI/FAIB - Engrave T/N number using Marktronic engraver as per DWG.

130 - QC8- Inspect parts - second check

150 - -Issue P/O to ATG: 44160 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water

GR0002

Plex 7/10/19 9:03 AM Dart.lajeunesse.marie

seal -Certificate of Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	2.1000 ft (.35 ea)	105-Bandsaw - 1	5195468 - 2.45

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Bandsaw - 1	M6061T6B1.500X2.500	2	27	0

Part Specifications

Specifications could not be found.

Plex 7/10/19 9:03 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	197537
Description: ADJUSTER Body		Part Number:	RBE703A94-1130-01-27
Inspection Dwg: RBE703A94-1130-01		Rev: K	Page 1 of 1

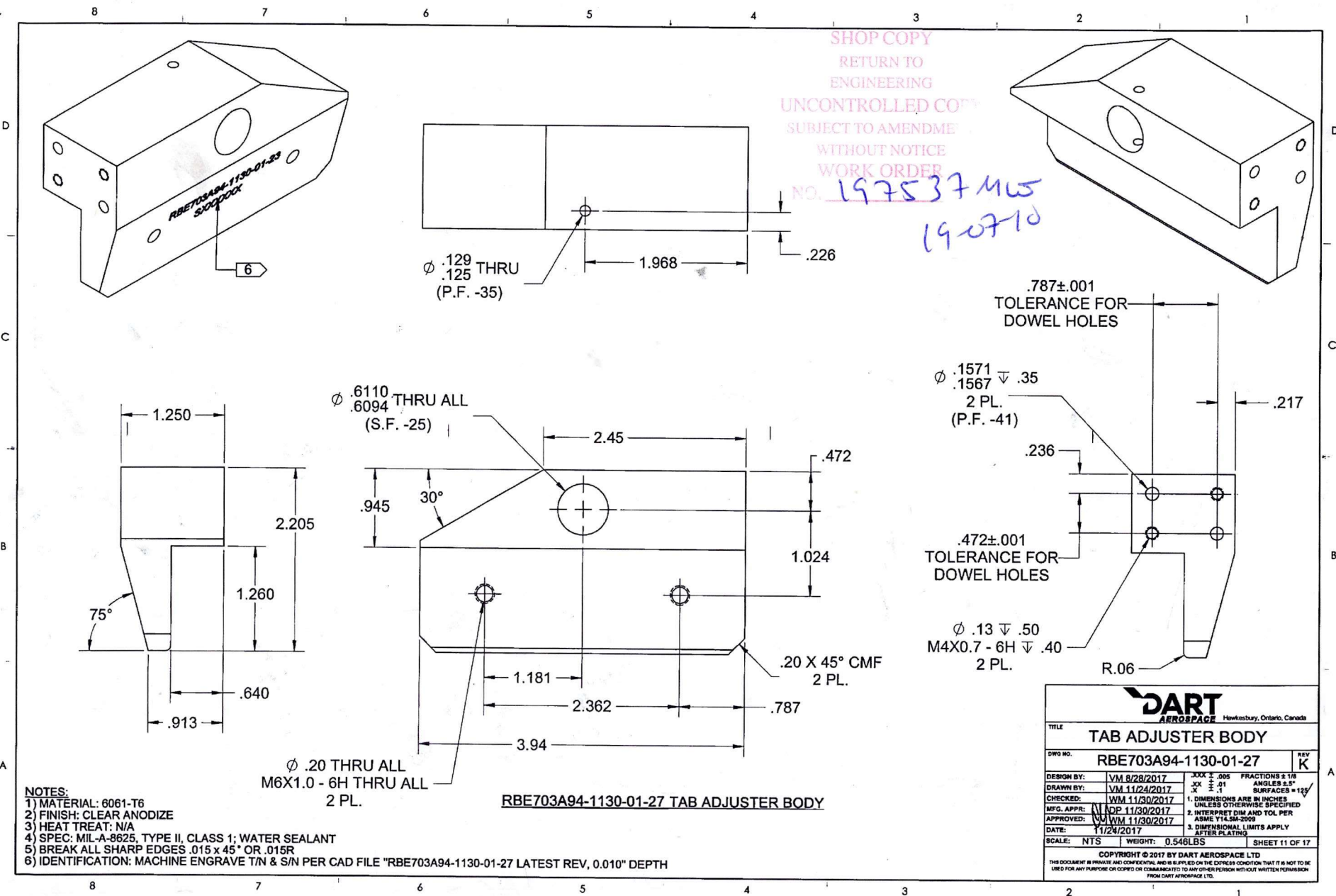
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/- 0.005	1.249			VERN	MGP-04
2.205	+/- 0.005	2.205			"	"
1.260	+/- 0.005	1.259			"	"
0.640	+/- 0.005	.639			"	"
3.94	+/- 0.010	3.939			"	"
2.362	+/- 0.005	2.360			"	"
0.787	+/- 0.005	.787			"	"
1.181	+/- 0.005	1.180			H-G	3/006
0.200 X 45°	+/- 0.010 X .5°	.200			VERN	MGP-04
1.024	+/- 0.005	1.0235			H-G	3/006
0.472	+/- 0.005	.472			VERN	MGP-04
M6X1.0	GH	G0			-	HT-271
0.6094	+0.0016 - 0.000	.6098			MIC	MGP-01
0.125	+0.004 - 0.000	.126			GP	✓
1.968	+/- 0.005	1.968			VERN	MGP-04
0.226	+/- 0.005	.225			"	"
0.787	+/- 0.001	.787			H-G	3/006
0.217	+/- 0.005	.216			"	"
0.236	+/- 0.005	.236			"	"
0.472	+/- 0.001	.4725			H-G	3/006
M4X0.7X.50	GH +/- 0.010	G0			✓	HT-281
0.1567 X .35	+0.0004 - 0.000 X 1/400	.157 X .352			G-P	✓

Measured by: A.L.A. / AK	Checked by: B.F.	QC Inspector:
Date: 7/26/19	Date: 19-07-29	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



DART AEROSPACE		Hawkesbury, Ontario, Canada	
TAB ADJUSTER BODY			
TITLE		REV K	
DWG NO.		RBE703A94-1130-01-27	
DESIGN BY:	VM 8/28/2017	XXX 2.005	FRACTIONS 2/16
DRAWN BY:	WM 11/24/2017	XX 2.1	ANGLES 2.5°
CHECKED:	WM 11/30/2017	X	SURFACES 125
MFG. APPR:	WM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	11/24/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	0.546 LBS
SHEET 11 OF 17		SHEET 11 OF 17	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044160



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044160

PO Date: 7/31/19

Due Date: 8/8/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-01

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197469	RBE350A94-3301-00	Tail Rotor Accelerator Support -Issue P/O: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	8/8/19	16 pcs	0 pcs	16 pcs	\$3.15/pcs	\$50.40
				X16			AUG 06 2019				DP
2	196745	RBW109-3130-53-113-1	Base -Issue P/O: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	8/8/19	6 pcs	0 pcs	6 pcs	\$3.64/pcs	\$21.84
				X6			AUG 06 2019				DP
3	197451	RBE350A93-3500-00-1	Body (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	-	8/8/19	20 pcs	0 pcs	20 pcs	\$1.95/pcs	\$39.00
				X20			AUG 06 2019				DP



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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PURCHASE ORDER

POHB044160



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	197537	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	8/8/19	6 pcs	0 pcs	6 pcs	\$1.87/pcs	\$11.22
										Grand Total:	\$122.46

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/1/19 4:00 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021203-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021203- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
31-Jul-2019		Jigar Patel		POHB044160				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3301-00 Rev.	RBE350A94-3301-00 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	16	16	0	0	0
2	RBW109-3130-53-113-1 Rev.	RBW109-3130-53-113-1 ANO-CLEAR [ANODIZE CLEAR] AS PER IAW MIL-A-8625F TYPE 2, CLASS 1 WATER SEALANT	ANODIZE CH	6	6	0	0	0
3	RBE350A93-3500-00-1 Rev.	RBE350A93-3500-00-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	20	20	0	0	0
4	RBE703A94-1130-01-27 Rev.	RBE703A94-1130-01-27 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	6	6	0	0	0

RECEIVED
 AUG 02 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

1 Box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J.P. JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

E-MAIL